

Need June 1st

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:21:16 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 32607	
Estimate Number : 12812	
P.O. Number : <i>N/A</i>	Part Number : D3610041
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3610 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32240	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/5/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.05.28	
Comment : est rev A new issue 07.03.28 EC	
est rev B released, changed mat'l EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140NB1500X15000	AISI 4140 Steel Bar
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*M103/43*

Comment: Qty.: 0.5775 f(s)/Unit * Total : 5.7750 f(s)
 AISI 4140 Steel Bar *M103/43*

J.F. 07/05/29

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 6.600 " long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA692 Rev: *AA* & Dwg D3610 Rev: *A*

2-Deburr per dwg D3610

J.F. 07/05/30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/05/30

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*Qmk 07/05/31**16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:21:16 AM
User: Kim Johnston

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Drawing Name: BRACKET

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Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'SINK AS PER DWG D3610

FF 07-06-04

10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/04

10

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m 10/601

BR/FL 07-06-04

(10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/06/04

(10X)

10.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nutplate

Batch: 18537-

11.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

RIVET

batch: 102404

7/6/5 (10)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Rivet Nut Plate as per Dwg D3610

m 07/06/05 x10

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/05

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: IS Date: 8/10/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:21:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32607

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57243

6/7/6/5

(10)

Job Completion



QC at final inspection w/o release

07/06/05

U 070605

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

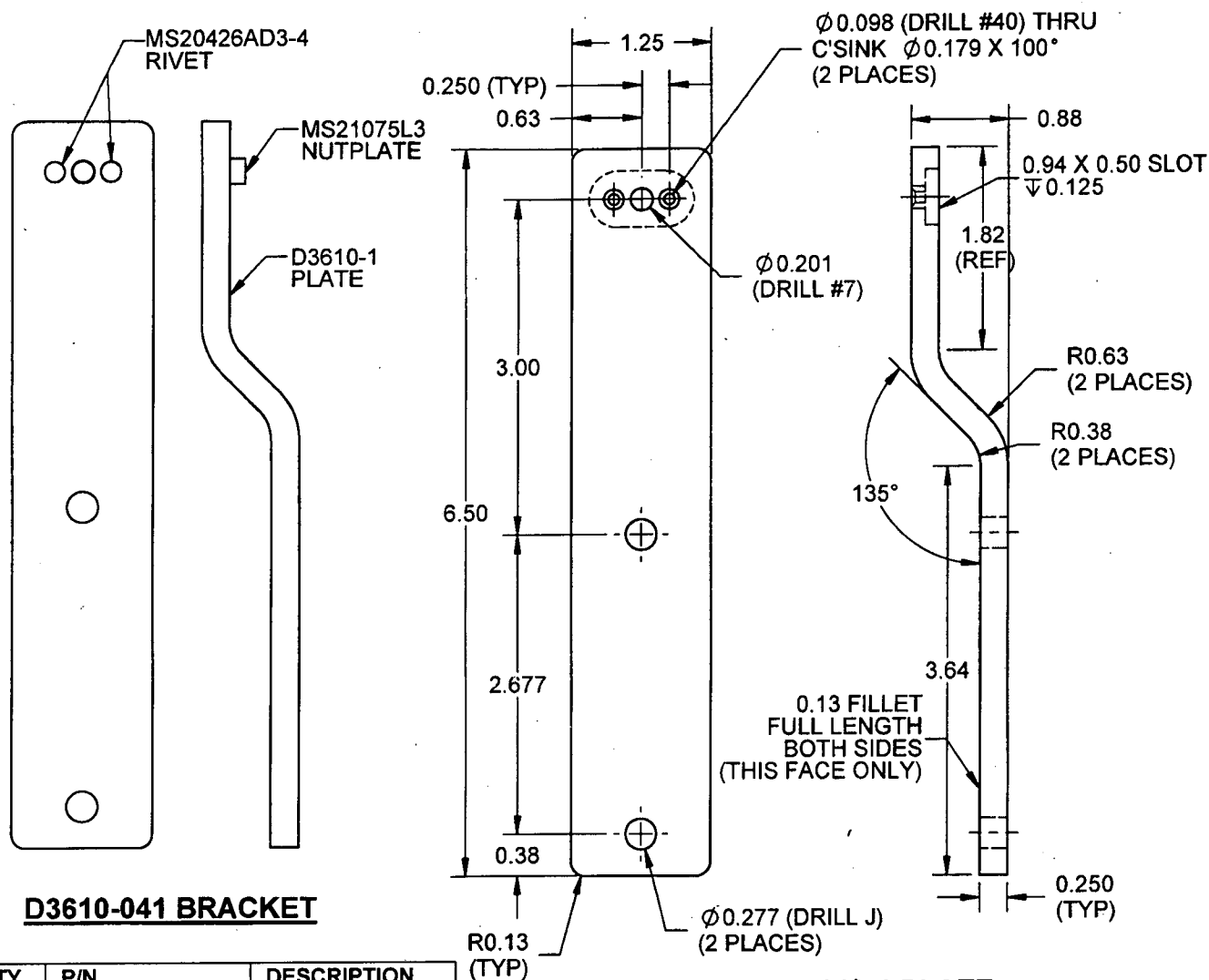
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20	TITLE BRACKET	SCALE 2:3	
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

D3610-041 NOTES:

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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RELEASED

07.04.25

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RETURN TO
ENGINEERING

UNCONTROLLED COPY

WITHOUT NOTICE

WORK ORDER

NO 32607

DART AEROSPACE LTD		Work Order: 32607
Description: Bracket		Part Number: 3610-1
Inspection Dwg: 03610 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25"	$\pm .030"$	1.249				
.250"	$\pm .010"$.250"				
.63"	$\pm .030"$.625"				
3.00"	$\pm .030"$	2.998"				
6.50"	$\pm .030"$	6.499"				
2.677"	$\pm .010"$	2.678"				
.38"	$\pm .030"$.375"				
$\emptyset .277"$	$\pm .006"$	$\emptyset .278"$				
$\emptyset .098"$	$\pm .005"$	$\emptyset .097"$				
.88"	$\pm .030"$.875"				
.94"	$\pm .030"$.934"				
.50"	$\pm .030"$.498"				
.250"	$\pm .010"$.250"				
$\emptyset .201"$	$\pm .005"$	$\emptyset .200"$				
R.125"	$\pm .030"$	R.125"				
W.125"	$\pm .010"$.123"				

Measured by: J.F.	Audited by:	Prototype Approval:
Date: 07/05/30	Date: 07/05/30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	